

Date: Monday, 20/04/2009 12:59:26 PM
 User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FLOAT SKID LH |
| Job Number | : 47288 | | |
| Estimate Number | : 12549 | | |
| P.O. Number | : | Part Number | : D206642513 |
| This Issue | : 20/04/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : N/A |
| First Issue | : 11 | Project Number | : N/A |
| Previous Run | : 42292 | Drawing Revision | : L |
| | Type : SKIDTUBES | Material | : |
| Written By | : | Due Date | : 10/05/2009 |
| Checked & Approved By | : <u>JLD 09.04.20</u> | Qty: | 1 Um: Each |
| Comment | : Est Rev:A New Issue 06-10-06 JLM Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM est rev D 07.06.06 added K642-513 EC Est Rev:E 07-12-05 ECN 1080p Rev:L DD verified by: Est Rev:F 08-12-09 chg as per DSI9427 DD verified by:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-513 CHG002

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|--------|-------------------------|
| 3.0 | 47288A | FLOAT SKIDTUBE ASSEMBLY |
|-----|--------|-------------------------|



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

1 x D206-642-545 Batch

| | | |
|-----|------------|------------------|
| 4.0 | D206648013 | GHW Modification |
|-----|------------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Kit

Batch:

| | | |
|-----|--------|--------------------|
| 5.0 | D29321 | Saddle LH Out, 206 |
|-----|--------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

206 Saddle Right side

batch:

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Process Sheet

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Drawing Name: FLOAT SKID LH

Job Number: 47288

Part Number: D206642513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29331

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Right
batch: 42978

7.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Right side
batch: 44554

8.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Right Side
batch: 43188

9.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
BOLT
batch: 108409

10.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bushing
batch: 46608

11.0

MS210433

Nut



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
Nut
batch: M111383

12.0

D36725

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER
batch: B35521 x4 B44679 x2

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number: 47288

Part Number: D206642513

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

AN5C11A batch M169898

(or AN5C12A)

Choice of bolt will depend on crosstube

SS 09/05/08 (X)

14.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch M169545

SS 09/05/08 (X)

15.0

D36727

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch B35522

SS 09/05/08 (X)

16.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

batch M111295

SS 09/05/08 (X)

17.0

D36723

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

PHENOLIC WASHER

batch 47023

SS 09/05/08 (X)

18.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

batch M111359

SS 09/05/08 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 47288

Part Number: D206642513

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|----------|-----|
| 19.0 | MS210434 | Nut |
|------|----------|-----|



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut
batch M111274

| | | |
|------|----------|----------|
| 20.0 | D3407043 | Tow Ring |
|------|----------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tow Ring
batch 43308

| | | |
|------|--------|--------|
| 21.0 | D34561 | Washer |
|------|--------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
washer
batch 46752 B43002

| | | |
|------|--------|--------|
| 22.0 | D34571 | Washer |
|------|--------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Inventory
batch B44793

| | | |
|------|-------|-----------|
| 23.0 | D2712 | Set Screw |
|------|-------|-----------|



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Set Screw
batch B43810 x9 B45247 x1

| | | |
|------|-------|---------------|
| 24.0 | D2934 | Saddle Spacer |
|------|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Saddle Spacer
batch 44296

| | | |
|------|-------|---------------|
| 25.0 | D2935 | Saddle Spacer |
|------|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Saddle Spacer
batch 44553

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 47288

Part Number: D206642513

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C37A

BOLT



Comment: Qty.: 34.0000 EACH(s)/Unit Total: 34.0000 EACH(s)

BOLT

batch:

M110890 x17 ✓

B11175 x11 ✓

M110898 x4 ✓

M110396 x2 ✓

SS 09/05/08 (X)

27.0

AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

BOLT

batch:

M169771

SS 09/05/08 (X)

28.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

BOLT

batch:

M167551

M169323

SS 09/05/08 (X)

29.0

AN960C10L

washer



Comment: Qty.: 72.0000 Each(s)/Unit Total: 72.0000 Each(s)

washer

batch:

M111548

SS 09/05/08 (X)

30.0

D36721

Phenolic Washer



Comment: Qty.: 72.0000 Each(s)/Unit Total: 72.0000 Each(s)

PHENOLIC WASHER

batch:

B42329

SS 09/05/08 (X)

31.0

D33963

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Inventory

batch:

45667

SS 09/05/08 (X)

32.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

bolt

batch:

M167551

SS 09/05/08 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Drawing Name: FLOAT SKID LH

Job Number: 47288

Part Number: D206642513

Job Number:



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|---------|-----------------------|---------------|
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|------|---------|------|
| 33.0 | AN5C15A | Bolt |
|------|---------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
batch M 69148

| | | |
|------|---------|--|
| 34.0 | AN5C32A | |
|------|---------|--|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
bolt
batch M 167463

| | | |
|------|---------|--|
| 35.0 | AN5C34A | |
|------|---------|--|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
bolt
batch M 110342

| | | |
|------|----------|-----|
| 36.0 | MS210435 | Nut |
|------|----------|-----|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch M 110180

| | | |
|------|--------|---------|
| 37.0 | D34521 | Bracket |
|------|--------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bracket

| | | |
|------|--------|---------|
| 38.0 | D34523 | Bracket |
|------|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket

| | | |
|------|--------------|-------|
| 39.0 | MS21919WDG28 | CLAMP |
|------|--------------|-------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
CLAMP

2854 28951 M 18847

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT SKID LH

Job Number: 47288

Part Number: D206642513

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT

M107376

8809105/08(x1)

41.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50105/14 @

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-642-513
Location: _____

Rev D

8809105/14 @

43.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09105/20 @

Job Completion



mf
09-05-18

| W/O: | | WORK ORDER CHANGES | | | | | |
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